

Date: Monday, 1/16/2006 4:19:45 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 25531	
Estimate Number : 10698	
P.O. Number : N/A	Part Number : D34631
This Issue : 1/16/2006 S.O. No. : N/A	Drawing Number : D3463 REV A B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : X B
Previous Run : 25341	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/23/2006
Checked & Approved By : SEE COMMENT BELOW	Qty: 1 Um: Each
Comment : EST REV. A 05.11.17 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M316TR100W120	Inventory
-----	---------------	-----------



Comment: Qty.: 2.1872 f(s)/Unit Total : 2.1872 f(s)
AISI 316 SS seamless tubing 1.00" OD X 0.120 wall
(M316TR1.00w120)
Batch: 110457

FF 06-01-19

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 25.00" long 25.28" LONG

06-01-17

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Bend as per dwg D3463

2-Trim to lenght per dwg D3463

3- Deburr

FF 06-01-19

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP
Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

06-01-15

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1- Drill as per dwg D3463

(drill holes ϕ .125" both ends)

MS 06/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:19:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25531

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr as per dwg D3463

M8 06/01/21

1

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/01/21

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06.01.31

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AA 06/01/31

①

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/02/01

①

06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25531
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

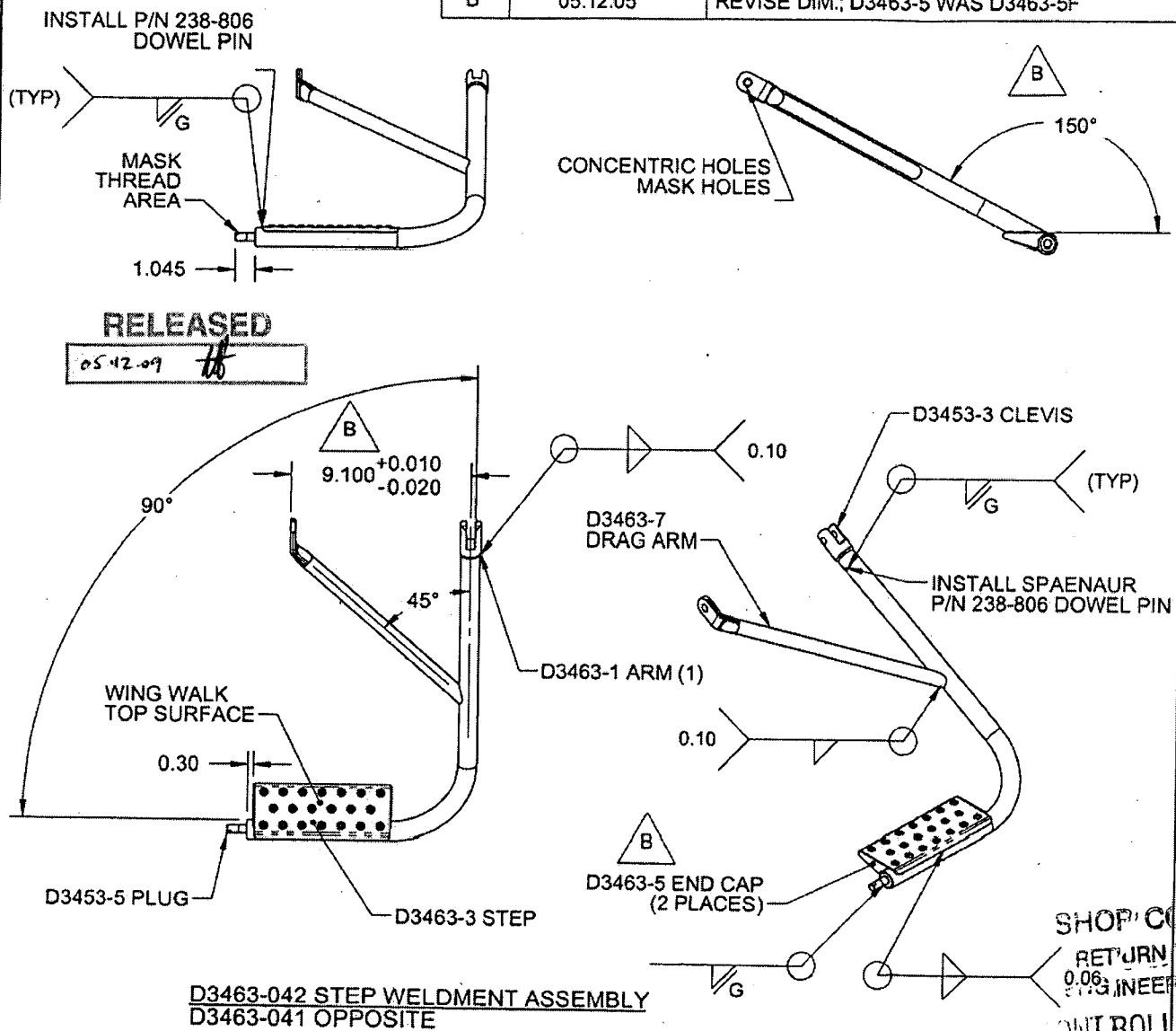
[illegible]

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



**NOTES:**

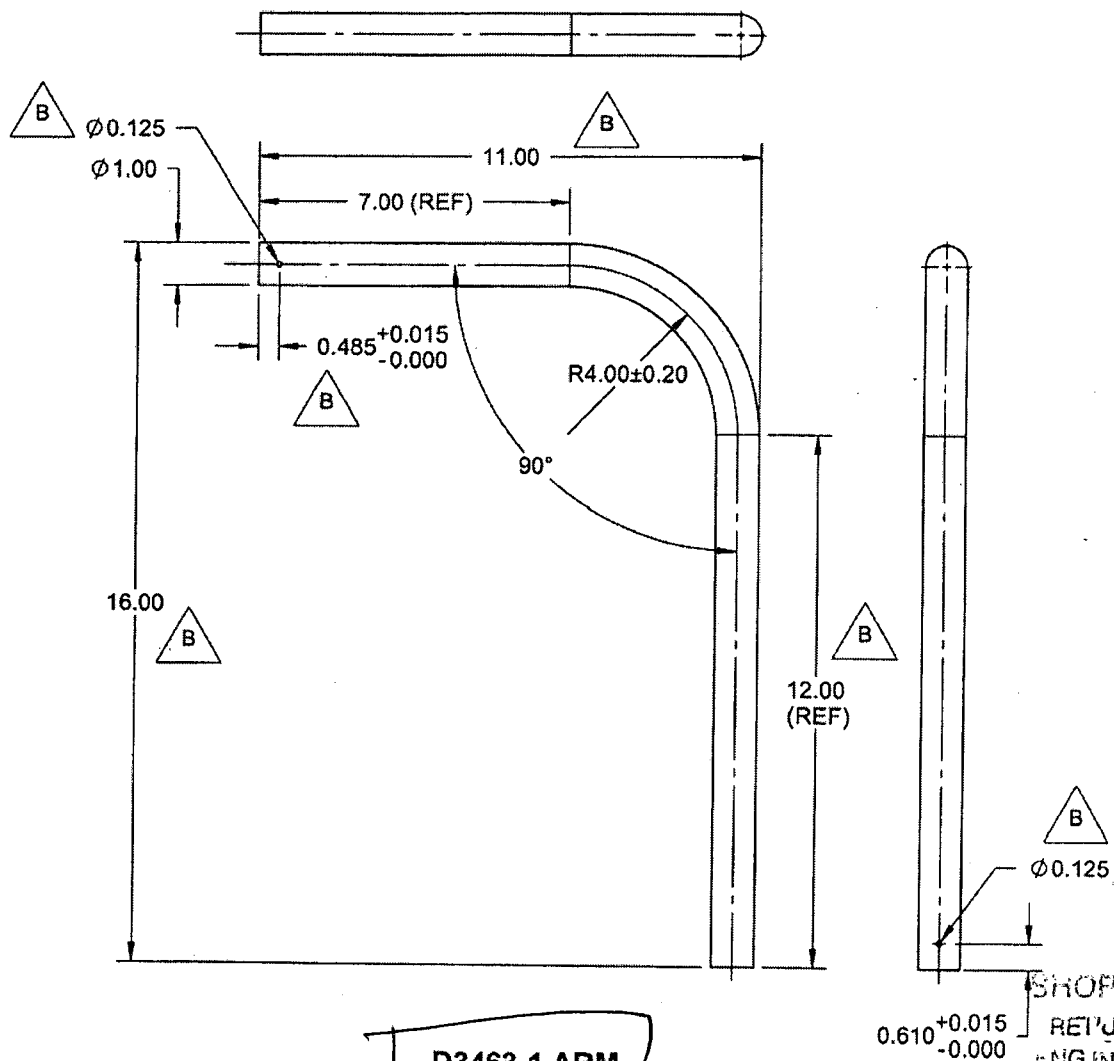

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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WORK ORDER

NO. 25531

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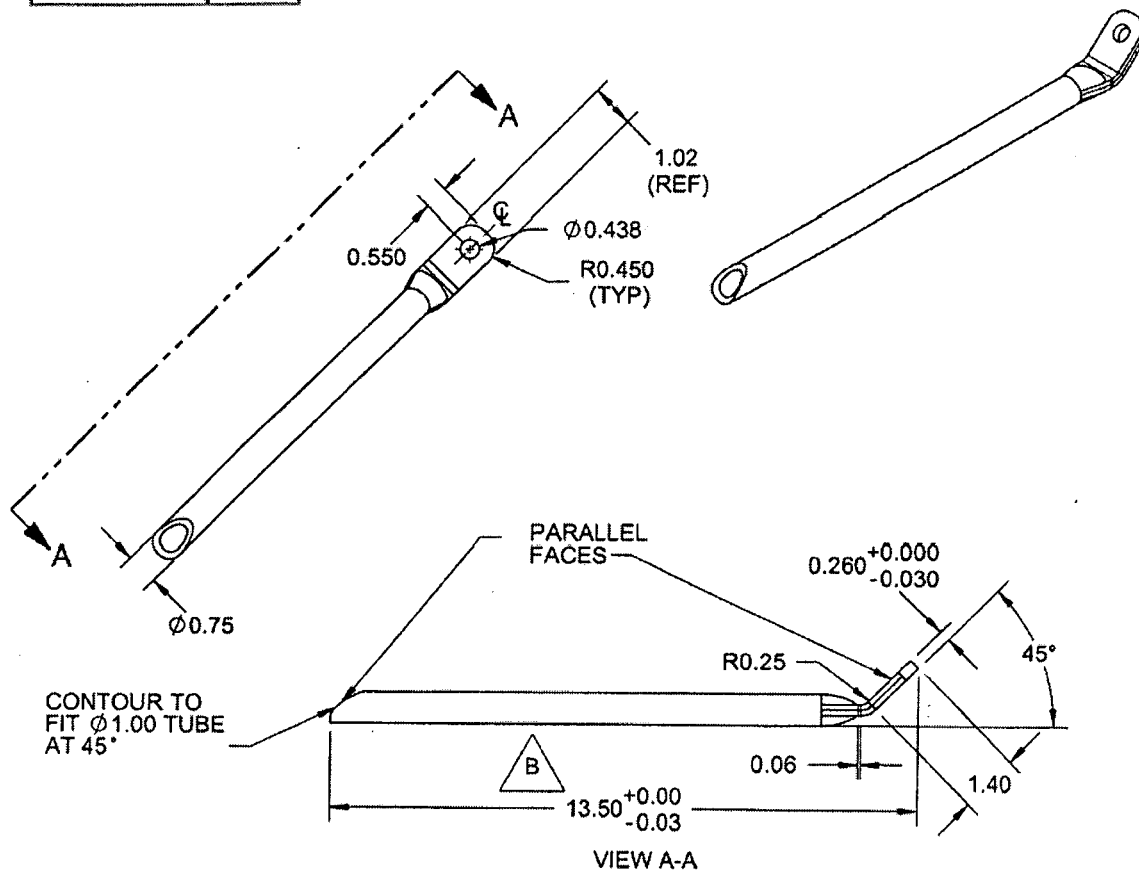
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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.09 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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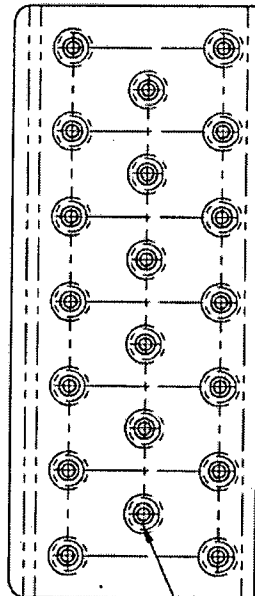
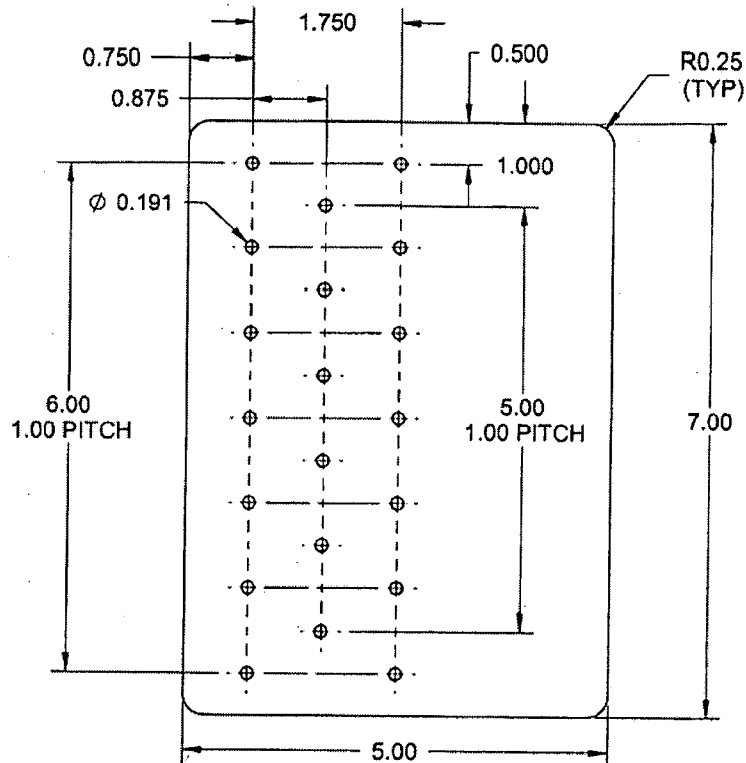
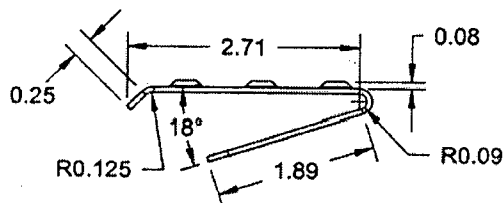
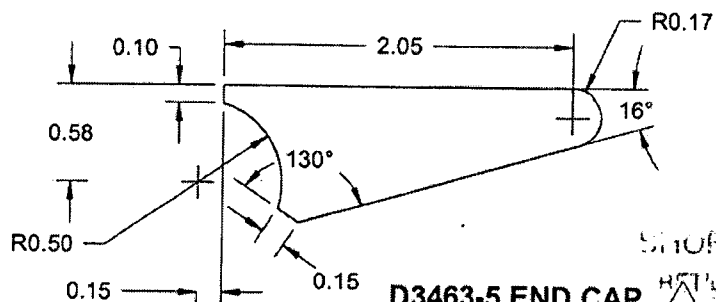
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.09 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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